



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4686-1

Job Sheet 175835



Part No: D4686-1

Job Qty: 80 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/11/18

Job Tracking No:

Due Date: 4/27/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: D4686 REV:B IPP REV:A 13.02.20 NEW ISSUE DD VERF:JLM IPP REV:B 13-06-15 NEW LENGHT JLM
VERIFIED BY:DD IPP REV:C 13.11.14 AS PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	80 Ea	4/26/18	4/26/18	0.00	0.00	Start Up Machining-3		JB 18-04-23
100	Hardinge	80 pcs	4/26/18	4/26/18	0.01	2.34	Hardinge		JB 18-04-23
120	QC	80 pcs	4/26/18	4/26/18	0.00	0.00	QC8		JB 18/04/24
122	Outsource	80 pcs	4/26/18	4/26/18			MEI001-VC		CTB-427 AM/2018
124	Packaging	80 pcs	4/26/18	4/26/18	0.00	0.00	Packaging2		DAS
126	QC	80 pcs	4/26/18	4/26/18	0.00	0.00	QC6		38
130	HandFinish	80 pcs	4/27/18	4/27/18	0.00	2.00	HandFinish1		SA 18-05-25
140	QC	80 pcs	4/27/18	4/27/18	0.00	0.00	QC7-4		BE
150	Packaging	80 pcs	4/27/18	4/27/18	0.00	0.00	Packaging3-2		DAS
160	QC21-SA	80 Ea	4/27/18	4/27/18	0.00	0.00	QC21		21 MAY 28 2018

Part Op 100 - Machine as per Folio FB164

Descriptions: 122 - HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED
PART ARE MADE FROM 6061-T6 MATERIAL

124 - ENSURE C OF C IS ATTACH

150 - ***STOCK IN SKIDTUBE CELL**

80039724 - Method

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6T0.750W.058	6061-T6 Round Tube .750 X.058W	35.2000 ft (.44 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6T0.750W.058	35	77	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.750Inches $\pm$ 0.010	0.760 0.740		Reference, Diameter
2	Spacer	0.058Inches $\pm$ 0.010	0.068 0.048		Reference
3	Spacer	5.200Inches $\pm$ 0.063	5.263 5.138		

Plex 4/11/18 8:56 AM dart.lacelle.linda



Container No: S063873



Part: D4686-1

Job No: 175835

Serial No/Batch: S063873

Revision: B

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/23/18



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K6A 1K7
Canada

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PURCHASE ORDER PO039724

Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039724
PO Date: 4/27/18
Due Date: 5/16/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	175835	D4686-1	Spacer HEAT TREAT TO T4/T42 CONDITION MIN. UTS=30 KSI (60 HREW MIN) NOTE: DETAIL C OF C REQUIRED PART ARE MADE FROM 6061-T6 MATERIAL	Firmed	5/16/18	80 pcs 87	0 pcs 87x	80 pcs	\$8.3375/pcs A1865/15	\$667.00
Grand Total:										\$667.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CT

Plex 5/14/18 3:58 PM dart.tsimiklis.chrisoula

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450-491-6454

Certificat de Conformité

Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
327313	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
32724	N/A	AL-8061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	36 - 44 %IACS		
HARDNESS	80 HREW MIN	10	68 - 72,5 HREW
			MESURE EN HR15TW = 87-89 HR15TW

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
80	5,55	D4686-1 (80) D4686-1 JOB. 175835 1 BOITE DE CARTON

11/5/18

COMMENTAIRES / comments

APPROUVÉ par / Approved by:



DATE: 2018-05-11

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

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COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
39724	N/A	AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

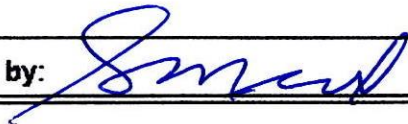
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	36 - 44 %IACS		
HARDNESS	80 HREW MIN	10	68 - 72,5 HREW
MESURE EN HR15TW = 67-69 HR15TW			

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
80	5,55	D4686-1 (80) D4686-1 JOB. 175835 1 BOITE DE CARTON

11/5/18

COMMENTAIRES / comments

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Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
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COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
39724	N/A	AL-6061		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications SOL ANNEAL SINGLE AGING TO CONDITION T42				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
CONDUCT	36 - 44 %IACS	10 (60 kHz)	40 - 41 %IACS	
HARDNESS	60 HREW MIN	10	68 - 72.5 HREW MESURE EN HR15TW = 67-69 HR15TW	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
80	5.55	D4686-1 (80) D4686-1 JOB. 175835 1 BOITE DE CARTON		

COMMENTAIRES / comments

SOL. ANNEAL 985F, 30 MIN

AGE HARDEN AMBIANT 96 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification.

All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée.

Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

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APPROUVÉ par / Approved by:

Isabel Otero

Isabel Otero
QA Technician



DATE: 2018-05-14